

FERMILAB

Welder Qualification Test Record

COPY

Welder's Name Leonard Harbacek Ident No. 122261 Date 03/19/99

Welding Process GTAW Type Manual

Test in Accordance With WPS # ES-155003 Root Open

Material Specification SA 53-B To Material Specification SA 53-B

P-No 1 To P-No 1 Thickness .280" Diam 6"

Filler Metal Specification SFA A5.18 Classification ER-70S-2 F-No 6

Thickness Deposited .280

Backing Argon Gas Shielding Argon

Position 6-G Progression Upward

Electrical Characteristics: Current DC Polarity Straight

Thickness Qualified .560" Max Diameter Qualified 2-7/8" O.D. and over

GUIDED BEND TEST RESULTS

Specimen No	Type	Figure	Results
1	Face	QW-462.3a	Acceptable
2	Face	QW-462.3a	Acceptable
3	Root	QW-462.3a	Acceptable
4	Root	QW-462.3a	Acceptable

Test Conducted By IFR Engineering Test No. 008-09-01 Date 3/19/99

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

By: 

Date: 4/22/99

FERMILAB

Welder Qualification Test Record

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Welder's Name Leonard Harbacek Ident No. 122261 Date 03/19/99

Welding Process SMAW Type Manual

Test in Accordance With WPS # ES-155000 Root Open

Material Specification SA 53-B To Material Specification SA 53-B

P-No 1 To P-No 1 Thickness .280" Diam 6"

Filler Metal Specification SFA A5.1 Classification E6010/E7018 F-No F3/F4

Thickness Deposited .280

Backing None Gas Shielding N/A

Position 6-G Progression Upward

Electrical Characteristics: Current DC Polarity Reverse

Thickness Qualified .560" Max Diameter Qualified 2-7/8" O.D. and over

GUIDED BEND TEST RESULTS

Specimen No	Type	Figure	Results
1	Face	QW-462.3a	Acceptable
2	Face	QW-462.3a	Acceptable
3	Root	QW-462.3a	Acceptable
4	Root	QW-462.3a	Acceptable

Test Conducted By IFR Engineering Test No. 008-09-01 Date 3/19/99

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

By:  4/22/99

Date: 4/22/99